

**Work Order ID 62432**

Page 1

September 30, 2010 8:00:11 AM

Item ID: D4172-041

Accept



Setup Start



Revision ID:

Item Name: Pod Mounting Frame Assembly

Stop



Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZDate: 10/9/30 Tooling:

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D4172	A

100



Small Fab

Memo

0.00

EC 10-10-14

Small Fab

1- Transfer drill holes, deburr and assemble as per dwg

110



QC

QC5- Inspect part completeness to step on W/O

0.00

1 10/10/10

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 62432**

Page 2

September 30, 2010 8:00:11 AM

Item ID: D4172-041

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Start Date: 9/30/10 Start Qty: 1.00



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Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

10-10-18

1

Powder Coating

Memo

0.00

\*\*\* Mask prior to powdercoat as per notes.\*\*\*

Start Time: 2:45

Oven Temperature: 320

Finish Time: 3:15

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

10/10/19

1

0

140



Packaging

Packaging

Identify as per dwg & Stock Location: *Conway*

0.00

Memo

0.00

10 10 21 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 1

September 30, 2010 8:00:11 AM

Work Order ID: 62432



Parent Item: D4172-041



Parent Item Name: Pod Mounting Frame Assembly

Start Date: 9/30/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-043 		Manufactured	No			100	Each	0.0000	1	1			
Z-Shape Section Assembly, LH 		Manufactured	No			100	Each	0.0000	1	1			
D4172-044 		Manufactured	No			100	Each	0.0000	1	1			
Z-Shape Section Assembly, RH 		Manufactured	No			100	Each	0.0000	5	5			
D4172-047 		Manufactured	No			100	Each	0.0000	1	1			
Crossbar Assembly 		Manufactured	No			100	Each	0.0000	1	1			
D4180-1 		Manufactured	No			100	Each	0.0000	1	1			
Gusset 		Manufactured	No			100	Each	0.0000	1	1			
D4180-2 		Manufactured	No			100	Each	0.0000	1	1			
Gusset 		Manufactured	No			100	Each	0.0000	1	1			
D4180-3 		Manufactured	No			100	Each	0.0000	1	1			
Gusset 		Manufactured	No			100	Each	0.0000	1	1			
D4180-4 		Manufactured	No			100	Each	0.0000	1	1			
Gusset 		Manufactured	No			100	Each	0.0000	1	1			
D4180-5 		Manufactured	No			100	Each	0.0000	1	1			
Gusset 		Manufactured	No			100	Each	0.0000	1	1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Page 2

September 30, 2010 8:00:11 AM

Work Order ID: 62432



Parent Item: D4172-041



Parent Item Name: Pod Mounting Frame Assembly

Start Date: 9/30/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D4180-6



Manufactured

No

100

Each

0.0000

1

1

B61929



BT (0-10-13)

Gusset

D4181-1



Manufactured

No

100

Each

0.0000

1

1

B61885



BT (0-10-13)

Pod Frame Platform

CR3213-4-04



Purchased

No

100

Each

200.0000

38

38

104291



BT (0-10-13)

Rivet

CR3213-4-06



Purchased

No

Location

ST312

Loc Qty

200

Loc Code

115742

100

Each

99.0000

24

24

115693



BT (0-10-13)

cherry rivet

MS24694-809-500



Purchased

No

Location

ST312

Loc Qty

99

Loc Code

115698

100

Each

50.0000

4

4

M 115531



BT (0-10-13)

Screw, Flat Head

MS24694-809-500



Purchased

No

Location

ST303

Loc Qty

50

Loc Code

115708

100

Each

50

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

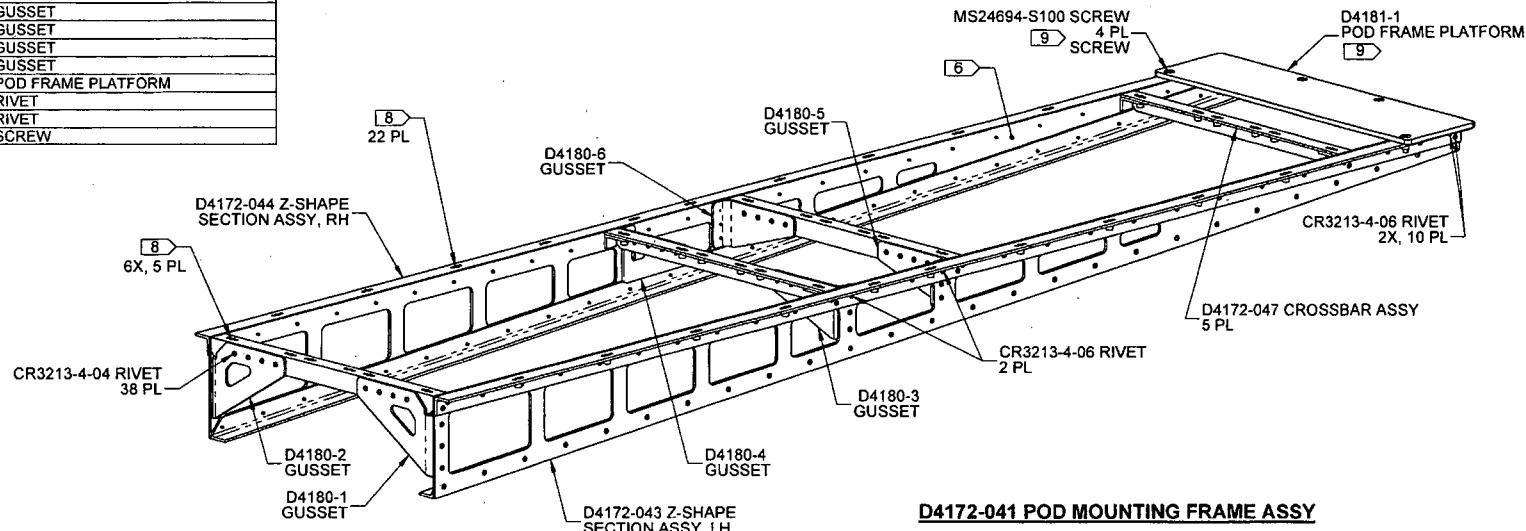
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

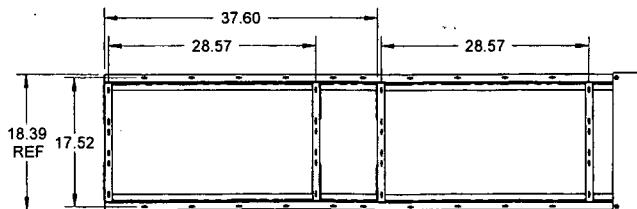
ITEM	QTY	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW

CL1019130

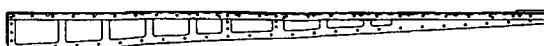
W10:62432



D4172-041 POD MOUNTING FRAME ASSY



SUPPLEMENTAL VIEWS



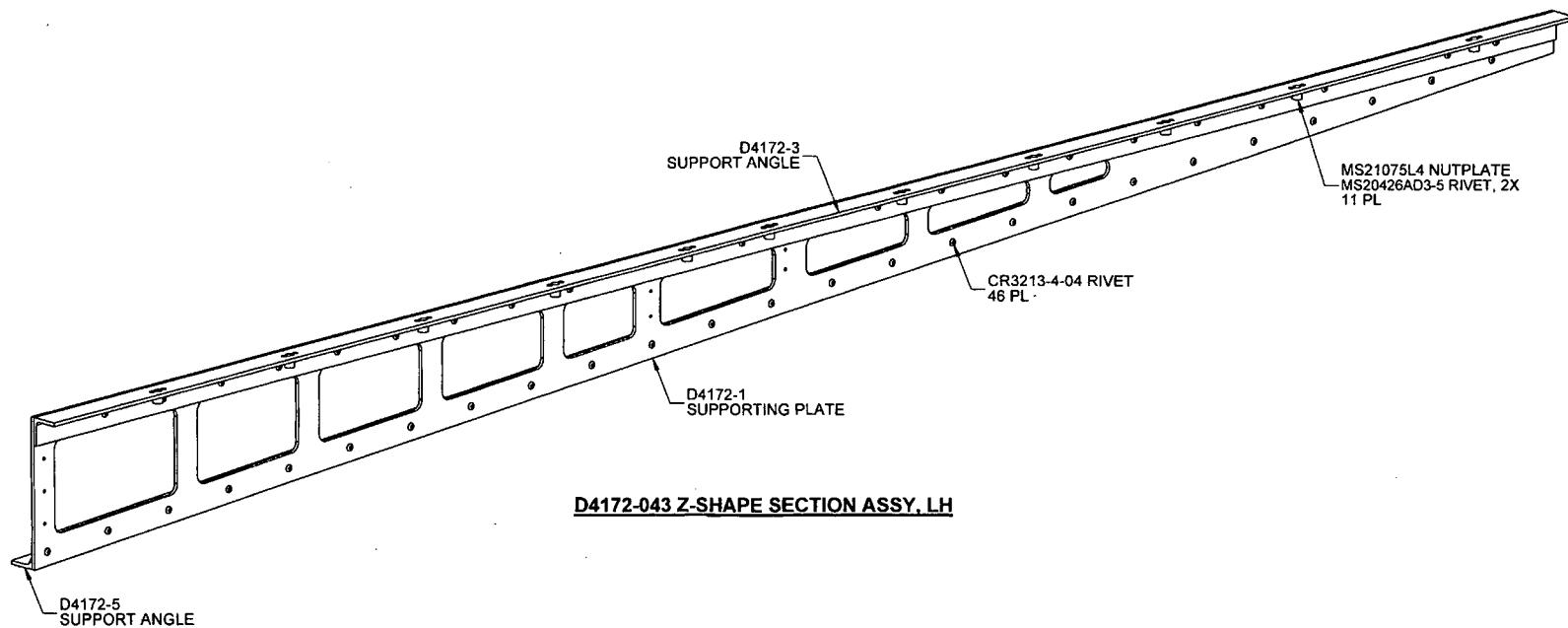
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 15.0 lbs
- 8) MASK PRIOR TO POWDER COATING
- 9) INSTALL AFTER POWDER COATING

RELEASED  
2010-09-29  
NP

A	NEW ISSUE	MB	10.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	12	DRAWING NO.	REV. A
MFG. APPR.	11	D4172	SHEET 1 OF 7
APPROVED	12	TITLE	SCALE
DE APPR.	12	POD MOUNTING FRAME ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	8	X D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



**NOTES:**  
 1) MATERIAL: NONE  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 2.13 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AB</i>	D4172	SHEET 2 OF 7
APPROVED	<i>AB</i>	TITLE	
DE APPR.	<i>AB</i>	SCALE	
DATE 10.09.15		NTS	

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**RELEASED**  
*2010-09-29*

8

7

6

5

4

3

2

1

ITEM	QTY	P/N	DESCRIPTION
	.044		
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE

D

D

C

C

B

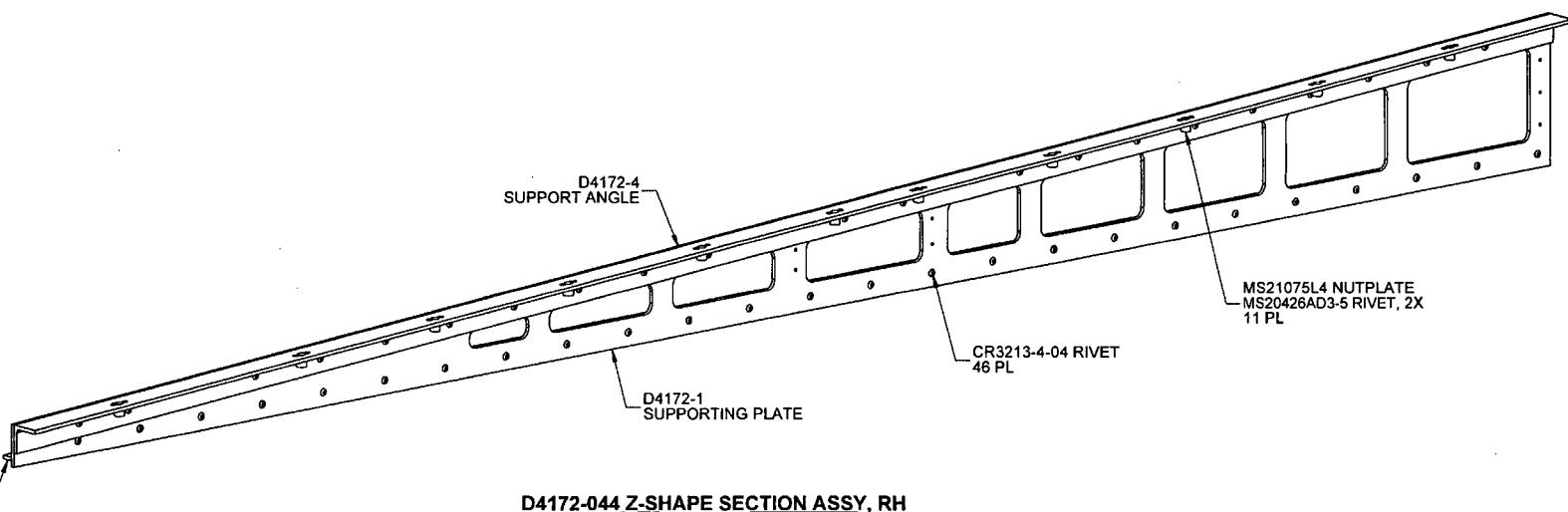
B

A

A

## NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.14 lbs

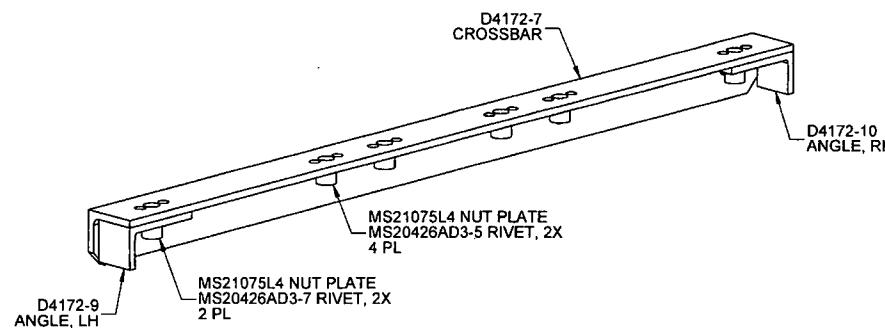
D4172-044 Z-SHAPE SECTION ASSY, RH

RELEASED  
2010-09-29  
JK

DESIGN	<i>JK</i>	DART AEROSPACE LTD	
DRAWN	<i>JK</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JK</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JK</i>	D4172	SHEET 3 OF 7
APPROVED	<i>JK</i>	TITLE	SCALE
DE APPR.	<i>JK</i>	POD MOUNTING FRAME ASSY	NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COPIED OR USED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

ITEM	QTY -047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET

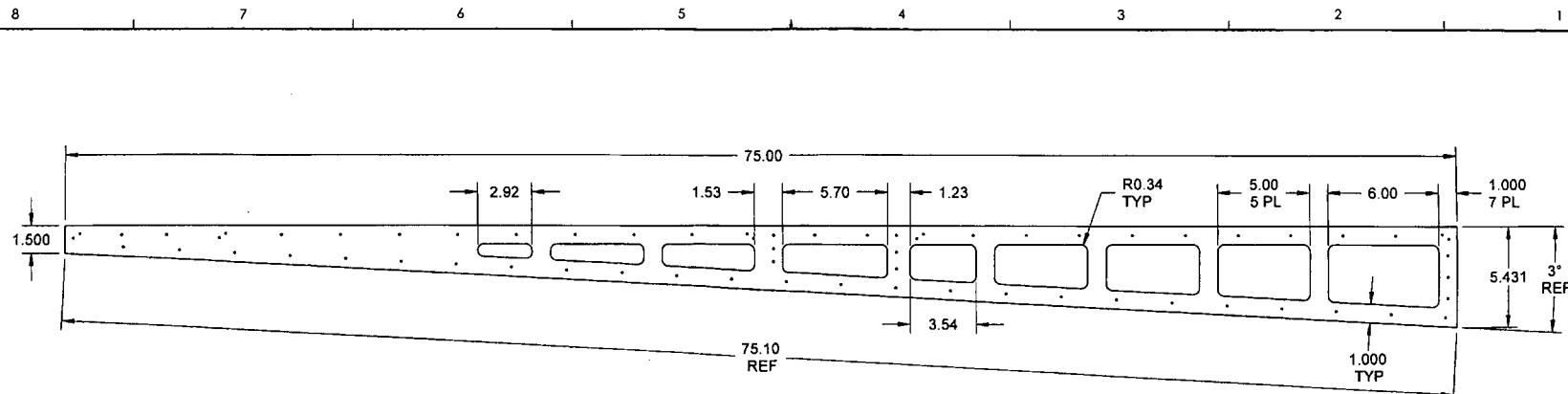
D4172-047 CROSSBAR ASSY

NOTES:  
 1) MATERIAL: NONE  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.18 lbs

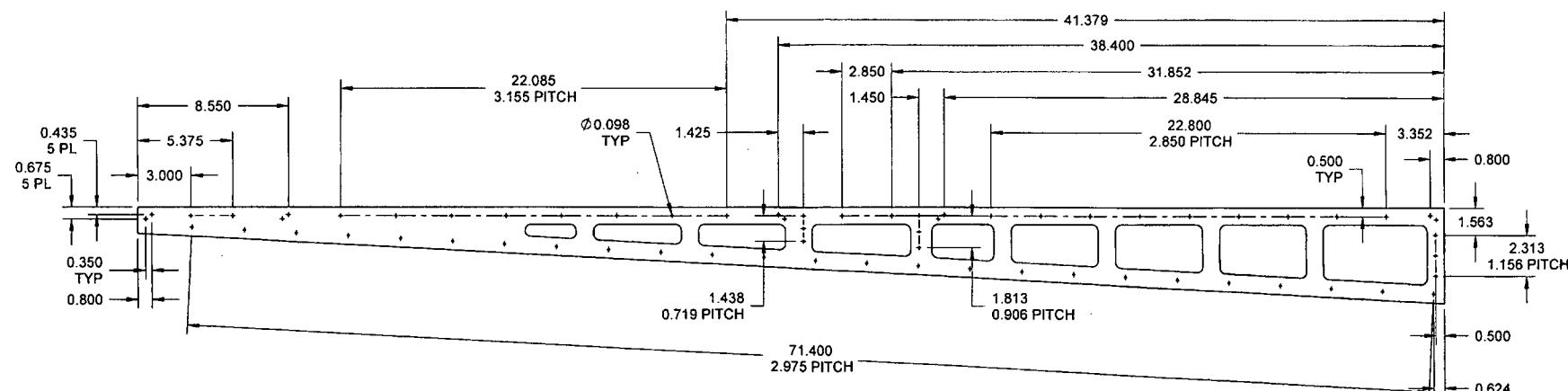
8 7 6 5 4 3 2 1

 RELEASED  
 2010-09-29  
*MO*

DESIGN	<i>JA</i>	DART AEROSPACE LTD	
DRAWN	<i>JA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>99</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>NA</i>	D4172	SHEET 4 OF 7
APPROVED	<i>100</i>	TITLE	SCALE
DE APPR.	<i>NA</i>	POD MOUNTING FRAME ASSY	NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS UNPUBLISHED SUBJECT TO A CONFIDENTIALITY AGREEMENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4172-1 SUPPORTING PLATE



SUPPLEMENTAL VIEW

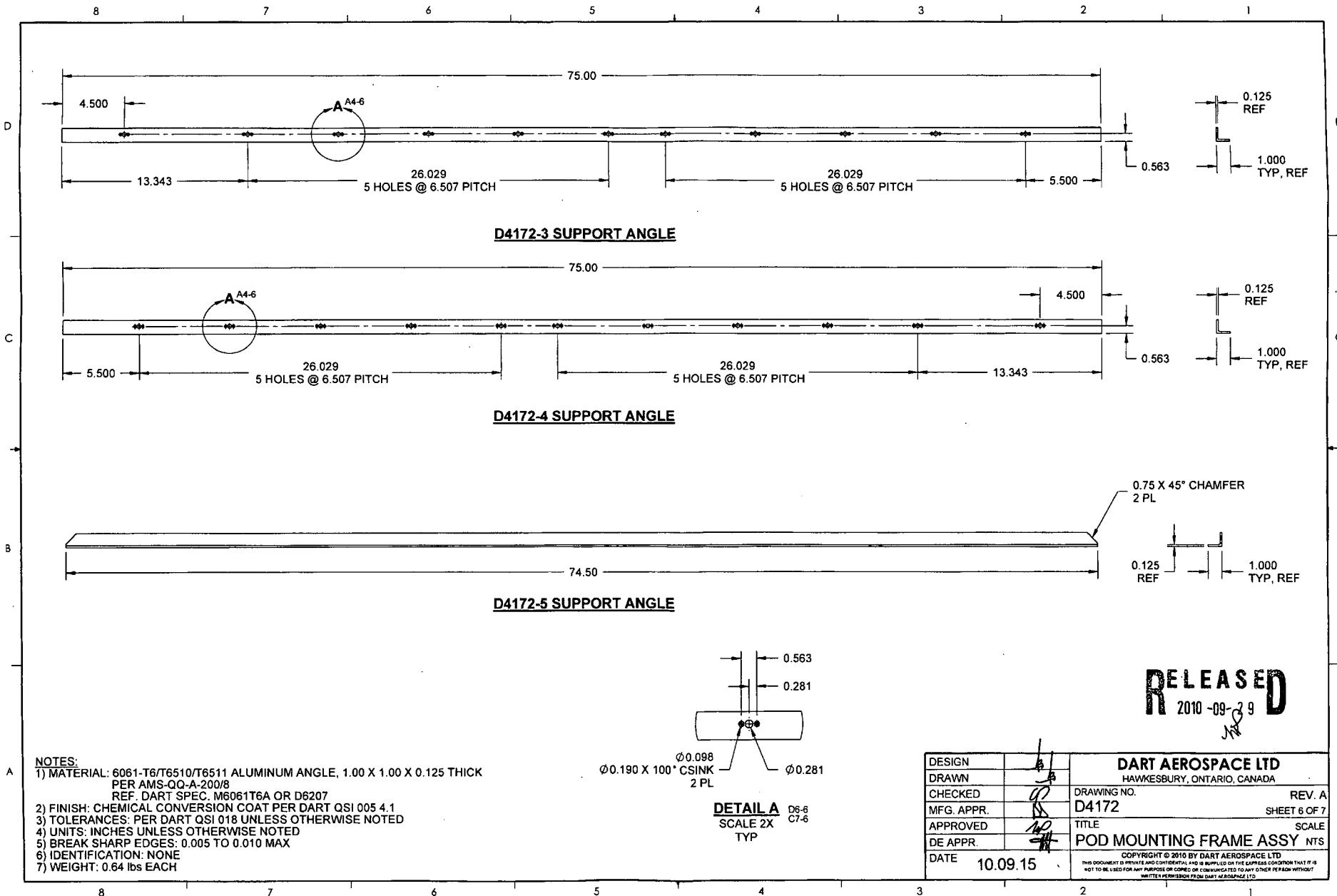
RELEASED  
2010-09-29

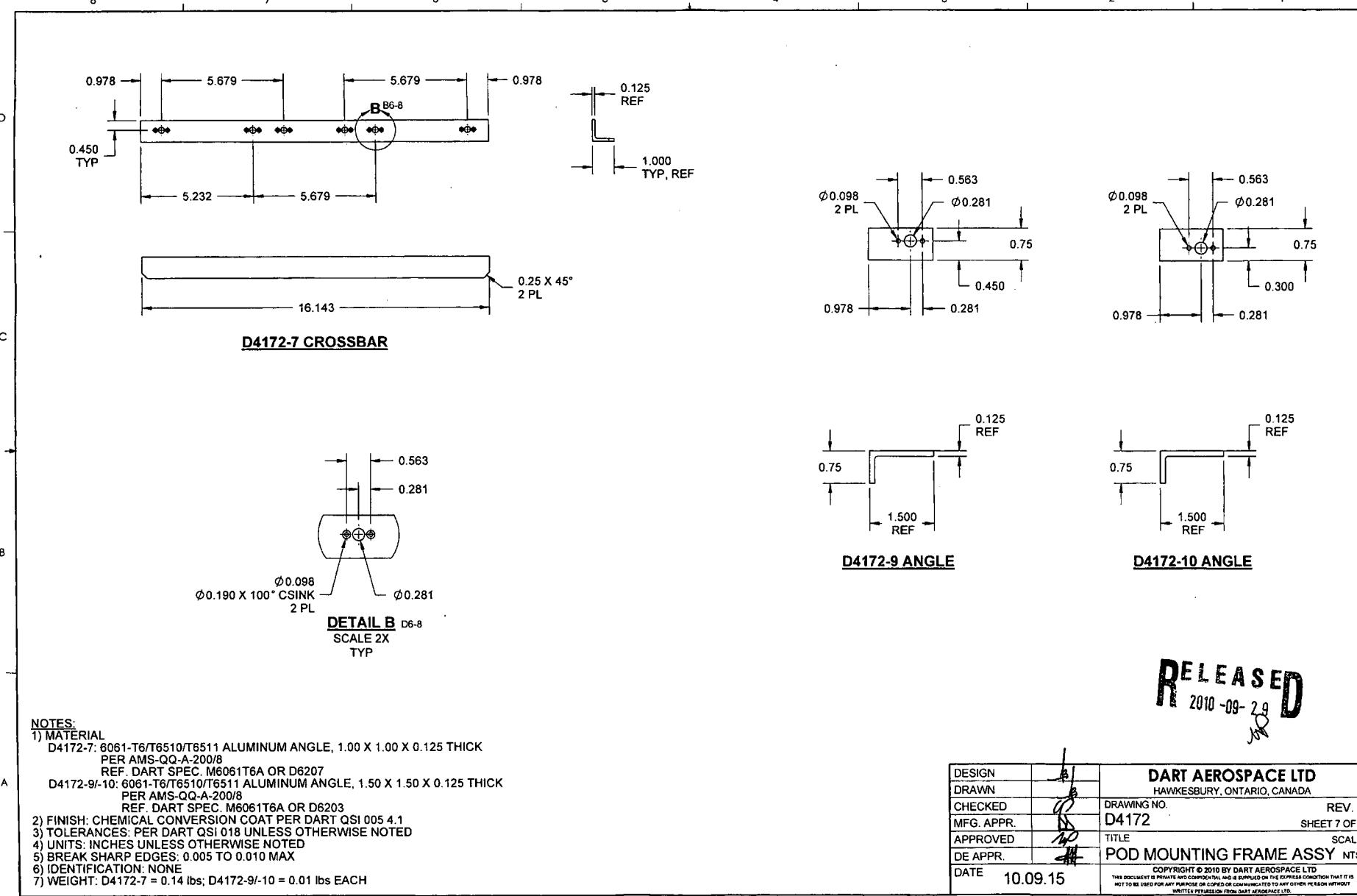
NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.78 lbs

DESIGN	<i>A</i>	DART AEROSPACE LTD
DRAWN	<i>A</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>Q</i>	DRAWING NO.
MFG. APPR.	<i>AA</i>	REV. A
APPROVED	<i>AA</i>	D4172
DE APPR.	<i>AA</i>	SHEET 5 OF 7
DATE 10.09.15		TITLE POD MOUNTING FRAME ASSY
SCALE NTS		

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DESIGN	1	DART AEROSPACE LTD
DRAWN	3	HAWKESBURY, ONTARIO, CANADA
CHECKED	10	DRAWING NO.
MFG. APPR.	11	REV. A
APPROVED	12	D4172
DE APPR.	13	SHEET 7 OF 7
DATE	10.09.15	SCALE
		NTS

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2010-09-29  
JW